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647.7308
Job Sheet 186265



Part No: 647.7308

Job Qty: 1 ea

Part Name: EC135 T3/P3 Cable Cutters (Removable Provisions Only)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/13/18

Job Tracking No:

Due Date: 12/28/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV N/C SHEETS 38-40

Ship Via:

7138

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		12/28/18	0.00	0.00	Start Up Stores/Pkg-1		DAS 20 2018 9-89
110	Packaging	1 pcs		12/28/18	0.00	0.00	Packaging1-1		46 DEC 22 2018 9-89
120	QC	1 pcs		12/28/18	0.00	0.00	QC4		46 DEC 22 2018 9-89
130	Packaging	1 pcs		12/28/18	0.00	0.00	Packaging3-1		46 DEC 22 2018 9-89
135	DC	1 pcs		12/28/18	0.00	0.00	DC		9-89 DEC 27 2018 9-89
140	QC21-FG	1 Ea		12/28/18	0.00	0.00	QC21		DEC 27 2018 70

Part Op 130 - Identify and pack for shipping as per PPP MPP-195 (647.7308)
Descriptions: 135 - Photocopy bluefile & type labels per PPP MPP-195 (647.7308)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
601.3011	P-Seal	1.4000 ft (1.4 ea)	90-Start up Operation	5006166
647.7501	Lower Cutter Assembly	1 Ea (1 ea)	90-Start up Operation	5125822
647.7702	Strut Assembly	2 Ea (2 ea)	90-Start up Operation	518826
647.7701	Strut Assembly	2 Ea (2 ea)	90-Start up Operation	5132792
647.0112	Strut Bracket	4 Ea (4 ea)	90-Start up Operation	5097192
MS21266-2N	Grommet	8 Ea (8 ea)	90-Start up Operation	512988
AN44-12A	Eyebolt	2 Ea (2 ea)	90-Start up Operation	5131204
AN665-34R	Clevis	4 Ea (4 ea)	90-Start up Operation	5135093
AN3-11A	Bolt	4 Ea (4 ea)	90-Start up Operation	5130322
AN4C7A	Bolt	4 Ea (4 ea)	90-Start up Operation	5095438
NAS6603-12	Bolt	4 Ea (4 ea)	90-Start up Operation	5007047
NAS6603-16	Bolt	4 Ea (4 ea)	90-Start up Operation	5131203
MS21042-3	Nut	4 Ea (4 ea)	90-Start up Operation	5108527
MS21042L4	Nut	4 Ea (4 ea)	90-Start up Operation	5112437
AN316C4R	Nut, Jam	4 Ea (4 ea)	90-Start up Operation	5130135
MS27039-08-13	Screw	4 Ea (4 ea)	90-Start up Operation	5016508
NAS1149FN832P	Washer	23 Ea (23 ea)	90-Start up Operation	5107194
NAS1149F0332P	Washer	8 Ea (8 ea)	90-Start up Operation	5133206
NAS1149C0432R	Washer	12 Ea (12 ea)	90-Start up Operation	5103890
NAS1149F0532P	Washer	2 Ea (2 ea)	90-Start up Operation	5180574
600.1012	Sealant PR1425B2 (#654 sem)	1 pcs (1 ea)	90-Start up Operation	5132228
601.2045	RTV (LOCTITE 598)	1 Ea (1 ea)	90-Start up Operation	5084065

Exp 5/19
Exp 12/18

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition
 Part: 647.7308 Job No: 186265 Serial No/Batch: S139224 Revision: NC Inspector: Exp Date: Instructions: URF17-611 Date: 12/20/18 Container No: S139224 1270 Aberdeen Street Hawkesbury, ON K6A 1T1 CANADA TEL: 1 813 632-5200 Email: sales@dartaero.com www.dartaero.com	

Root Cause		FAULT CATEGORY	
Environment	☐	Pressure/Forced	☐
Design	☐	Bending	☐
Doc/Data	☐	Centre Not Concentric	☐
Equip/Tooling	☐	Cracks	☐
Handling/Pre	☐	Crimp/Kink/Ripple/Wave	☐
Material	☐	Cuffs	☐
Internal Transport	☐	Crushing	☐
Tribal Knowledge	☐	Heat Treat	☐
LOA	☐	Wave/Twist in Tube	☐
Substation	☐	Marks/Chatter	☐
Past Expiry Date	☐		
Misidentified	☐		
No Re-verification	☐	Temperature/Cure	☐
Operator	☐	Set-up	☐
Offset/Setup	☐	BOM/Route	☐
Supplier	☐	Broken/Damage/Defect	☐
Training	☐	Inspection Incomplete/Unqualified	☐
Use for Testing	☐	Contamination	☐
Poor Information	☐	Countersink	☐
Rushing	☐	Cut Too Short	☐
Product Improvement	☐	Instructions Incomplete/Unclear	☐
Process Improvement	☐	Drill Holes	☐
Manufacturing Process	☐		
Past Due	☐		
OTHER :			

MS27039-08-19	Screw	5 Ea (5 ea)	90-Start up Operation
MS21042L08	Nut	9 Ea (9 ea)	90-Start up Operation
647.1702	Skid Deflector Assembly	2 Ea (2 ea)	90-Start up Operation
LN9025-0820K	Lock Tab Washer	8 Ea (8 ea)	90-Start up Operation
LN9037-08018	Screw	8 pcs (8 ea)	90-Start up Operation
93635A212	Bolt	4 Ea (4 ea)	90-Start up Operation
601.3902	Eye Bolt	2 Ea (2 ea)	90-Start up Operation
647.1405	EC135 Upper Cutter Assembly	1 Ea (1 ea)	90-Start up Operation

5164359
 5100409
 5136992
 5094434
 5084821
 5021320
 5026005
 5136940

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	600.1012	1	22	0
	601.2045	1	19	0
	601.3011	1	135	0
	601.3902	2	43	0
	647.0112	4	76	0
	647.1405	1	0	0
	647.1702	2	6	0
	647.7501	1	1	0
	647.7701	2	0	0
	647.7702	2	13	0
	93635A212	4	28	0
	AN3-11A	4	131	0
	AN316C4R	4	27	0
	AN44-12A	2	0	0
	AN4C7A	4	133	0
	AN665-34R	4	39	0
	LN9025-0820K	8	45	0
	LN9037-08018	8	137	0
	MS21042-3	4	180	0
	MS21042L08	9	1,539	0
	MS21042L4	4	2,014	0
	MS21266-2N	8	6	0
	MS27039-08-13	4	572	0
	MS27039-08-19	5	1,537	0
	NAS1149C0432R	12	1,850	0
	NAS1149F0332P	8	1,565	0
	NAS1149F0532P	2	1,127	0
	NAS1149FN832P	23	2,375	0
	NAS6603-12	4	59	0
	NAS6603-16	4	4	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐							
Misidentified ☐	Past Due ☐								